

5/40

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24283
<b>Description:</b> Window Assembly		<b>Part Number:</b>	D3136-043
<del>04.06.09</del> 18 05.09.14 Dwg: D3136 Rev. <u>BC</u>		<b>Qty:</b>	20
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JS	05.09.14	20
2	PG	Issue P/O: <u>2008653</u> Order D3136-3 per Dwg D3136 Supplier: -Canus Material: Polycast II Clear Acrylic sheet per MIL-P-5425 0.125" thick Apply 3M Protective Masking Film both sides <b>Material release note required</b>	JS	05/09/15	20
3	RG	Receive and Inspect for transit damage <b>Ensure that material release note is attached</b>	CZ	06/03/09	20
4	QC6	Inspect dimensions as per Dwg D3136	Z	06.03.10	20
5	GA	Trim back masking film as per Dwg D3136 and apply D3108-9 decals to inside surface of windows. <i>using Template D3136-3T1</i> D3108-9 Batch: <u>B 22608</u>	SB	06/03/14	20
6	GA	Engrave Part number and Batch number as per Dwg D3136 <i>*Template D3136-3T1</i>	SR	06/03/14	20
7	QC5	Inspect work to Step 6	Z	06.03.15	20
8	ST	Identify and Stock as D3136-043 <u>ST 127</u>	CZ	06/03/15	20
9	AC	Cost / part	JS	06.03.15	20
10	DC	Close W/O Inspect Level 21	H	06/03/15	20

JS 05.09.14

Rev	Date	Change	Revised By	Approved
A	04.02.04	New issue	KJ/DS	JS

RELEASED  
04.02.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 6/16/15

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**Chris Provencal**

---

**From:** "David Shepherd" <davids@dartaero.com>  
**To:** "Chris Provencal" <chrisp@dartaero.com>  
**Sent:** September 14, 2005 2:38 PM  
**Subject:** Re: D3136

This is an acceptable substitution. The flammability testing was conducted on the R22/R44 window program.

David

----- Original Message -----

**From:** Chris Provencal  
**To:** David Shepherd  
**Sent:** Wednesday, September 14, 2005 12:18 PM  
**Subject:** D3136

For The D3136-1/-3 Windows, is it acceptable to substitute the material:

"Plexiglas G Clear Cast Acrylic Sheet per LP-391 Type 1 Grade C, 0.125 thick"

in lieu of the

"Polycast II Clear Acrylic Sheet per MIL-P-5425 0.125 thick"

Sincerely,

**Chris Provencal**

***DART Aerospace Ltd.***

Email...[chrisp@dartaero.com](mailto:chrisp@dartaero.com)

Phone...613-632-3336

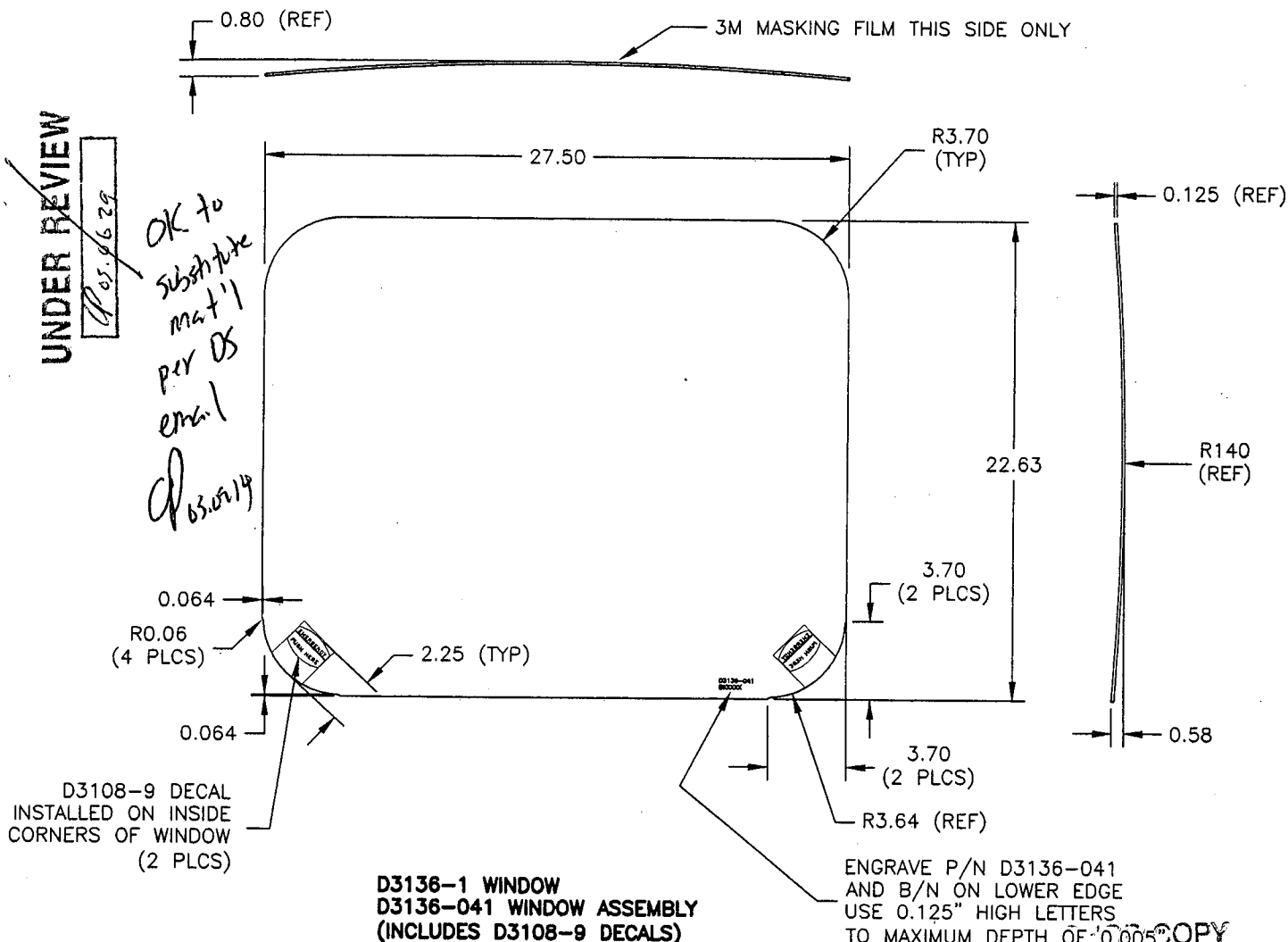
Fax.....613-632-4443

14/09/2005



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
				D3136	SHEET 1 OF 2
DATE	04.05.05			TITLE	SCALE
				WINDOW ASSEMBLY	1:8
A	02.04.18	NEW ISSUE			
B	04.01.21	ADDED D3136-3 AND D3136-043			
C	04.05.05	ADDED FORMING & ENGRAVING SPEC			

RELEASED  
04.05.12 *[Signature]*



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F  
b) DRAPE OVER D3136-T1 MOLD & CLAMP  
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS  
d) TRIM PER TEMPLATE D3136-1T2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

TURN TO  
DIMENSION

IF LED COPY

TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 24283

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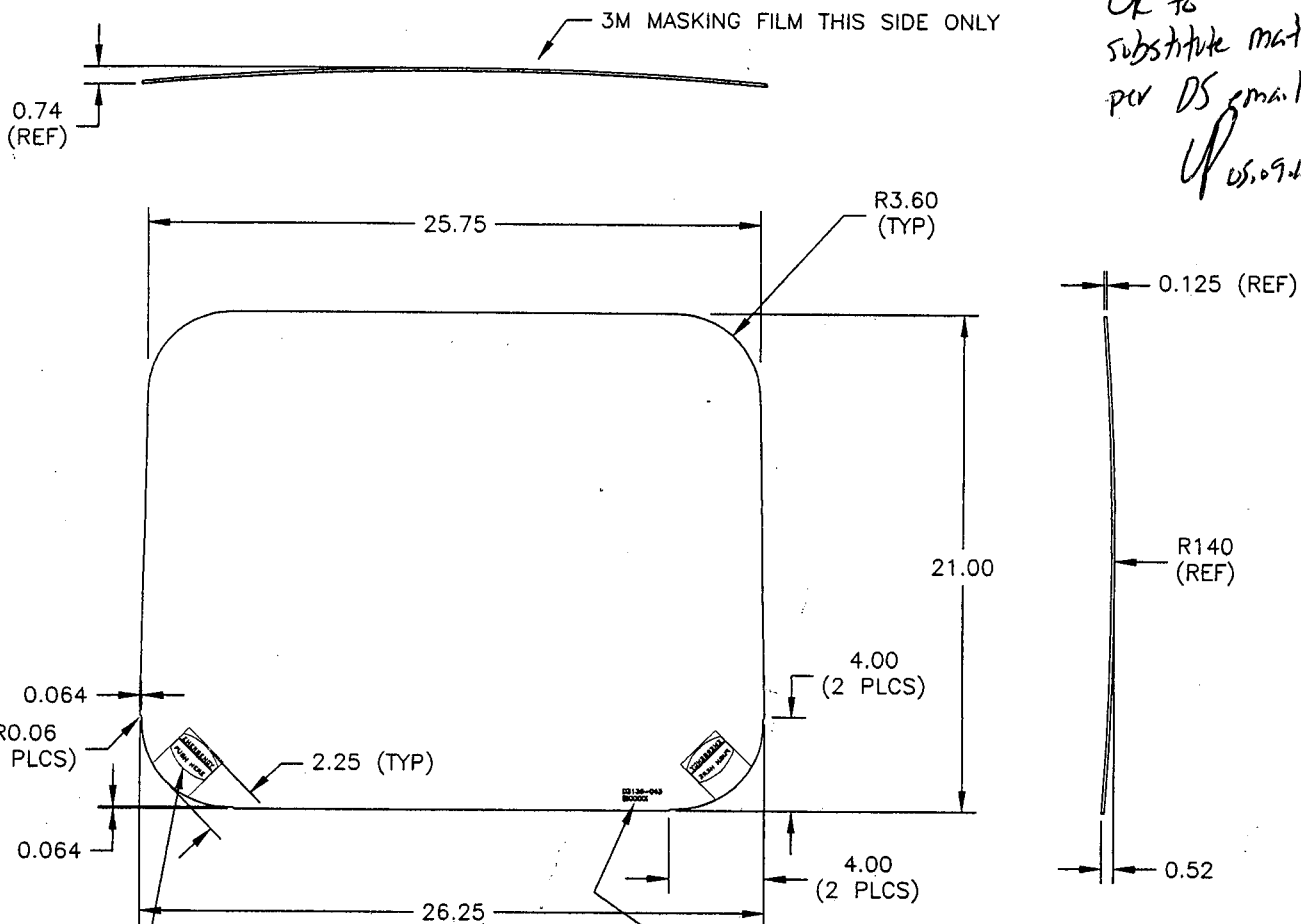


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3136	REV. C SHEET 2 OF 2
DATE 04.05.05		TITLE WINDOW ASSEMBLY	SCALE 1:8

RELEASED  
04.05.12

UNDER REVIEW  
05.06.29

OK to  
substitute mat'l  
per DS email  
05.09.07



D3108-9 DECAL  
INSTALLED ON INSIDE  
CORNERS OF WINDOW  
(2 PLCS)

**D3136-3 WINDOW  
D3136-043 WINDOW ASSEMBLY  
(INCLUDES D3108-9 DECALS)**

ENGRAVE P/N D3136-043  
AND B/N ON LOWER EDGE  
USE 0.125" HIGH LETTERS  
TO MAXIMUM DEPTH OF 0.005"

**NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F  
b) DRAPE OVER D3136-T1 MOLD & CLAMP  
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS  
d) TRIM PER TEMPLATE D3136-3T1

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Sep 13, 2005  
03:34 pm

Work Order No : 0024283  
Project Name : D3136-043  
Project For : WK540  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3136-043  
Description : Window Assembly  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 09-13-05  
Est Finish Date : 10-05-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

**CANUS PLASTICS INC.****300 Lisgar Street****Ottawa, ON****K2P 0E2**

Phone: 613 232 2657

Fax: 613 232 6214

info@canusplastics.com

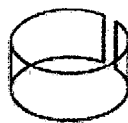
www.canusplastics.com

**Packing Slip** 123835**CUSTOMER NO. 163233****BILL TO: DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7****SHIP TO: SAME**

Attn: Accounts Payable

(613)632-3336

DATE	SHIP VIA	F.O.B.	TERMS		
03/07/06	Canpar	Our Dock	Net 30 days		
P.O. NUMBER	ORDER DATE	SALESPERSON			
2008653	03/07/06	TM			
PART NUMBER	DESCRIPTION	REQ.	QUANTITY SHIPPED	B.O.	
MFG-DARTD3136RC	D3136 REV C ACRYLIC WINDOW ASSY	20	20		



**CANUS** Plastics Inc

300 LISGAR ST  
OTTAWA, ONTARIO  
K2P 0E2  
PH: 613-232-2657  
FAX: 613-232-6214

Certificate of Conformance

Date: 3/07/06

To: DART AEROSPACE  
1270 ABERDEEN ST.  
HAWKESBUURY, ON  
K6A 1K7

P.O.#: 2008653

Order# 123835

The undersigned hereby certifies that the materials supplied and the items shipped under the above purchase order, are in conformance with, all applicable specifications and/or purchase order requirements. All reports of the materials supplied are on file and can be made available upon request.

<u>Quantity</u>	<u>Description</u>	<u>Specification</u>
20	ACRYLIC WINDOW	DWG# D3136 REV C

SIGNED: \_\_\_\_\_